

Date: Monday, 1/7/2008 3:38:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING BRACKET
 Job Number : 36617
 Estimate Number : 11964
 P.O. Number :
 This Issue : 1/7/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 35363
 Written By :
 Checked & Approved By :
 Comment : Est C 01.08.21 Added Finishing SM
 (Issue this IPP with part number D2053)
 Est Rev D now water jet 07-10-25 DD

Part Number : D2052
 Drawing Number : D2052 REV B/C
 Project Number : N/A
 Drawing Revision : KC
 Material :
 Due Date : 1/31/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S090 5052-H32 .090 Sheet



6



Comment: Qty.: 0.1355 sf(s)/Unit Total : 5.4180 sf(s)
 Material: 5052-H32, 0.090" Thick
 (M5052H3S.090)
 Batch: 3019 IB 8-1-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2052
 Dwg Rev: C IB 8-1-14
 Prog Rev: C

2-Deburr if necessary

08/01/15 (43)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-1-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/01/16 (43) counter

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D2053 using CNC Brake

08/01/16 (43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 36617

Part Number: D2052

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ccs
08/01/16 (48)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005

HP 08-01-21 (48)

8.0

POWDER COATING

POWDER COATING



M100700



(48X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref 4.3.5.8) as per QSI 005 4.3

M-1 08/01/24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/01/24 (48)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5152*

LC 08/01/28 (48)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208101/29

Job Completion



in 2008-1-28 (43X)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

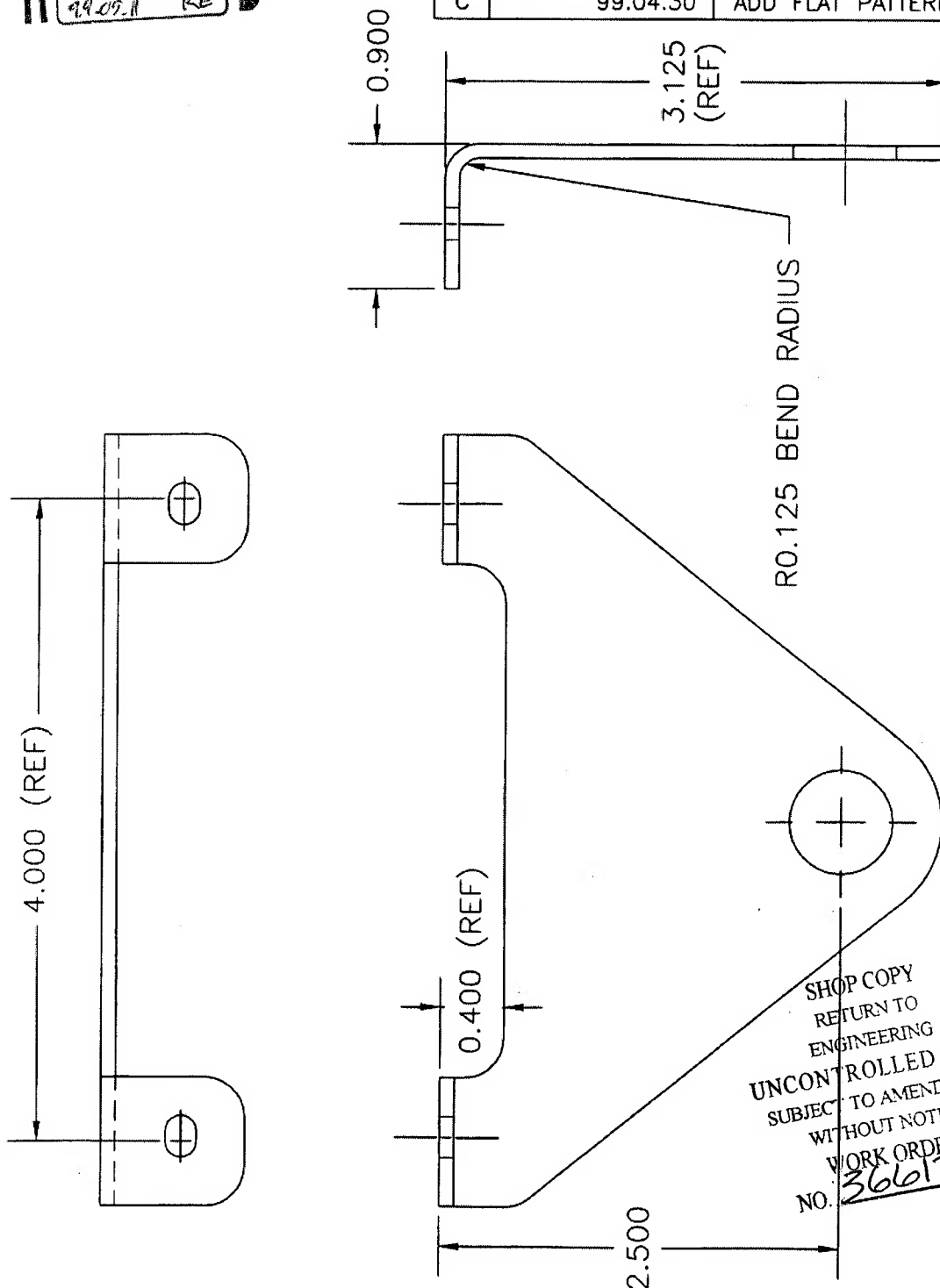
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED MF	DRAWING NO. D2052	REV. C SHEET 1 OF 2
DATE 99.04.30	TITLE BRACKET		SCALE 1:1
A	92.01.12	NEW ISSUE	
B	97.02.21	ADD SLOT TO FOOT	
C	99.04.30	ADD FLAT PATTERN	

RELEASED
99.05.11 KE

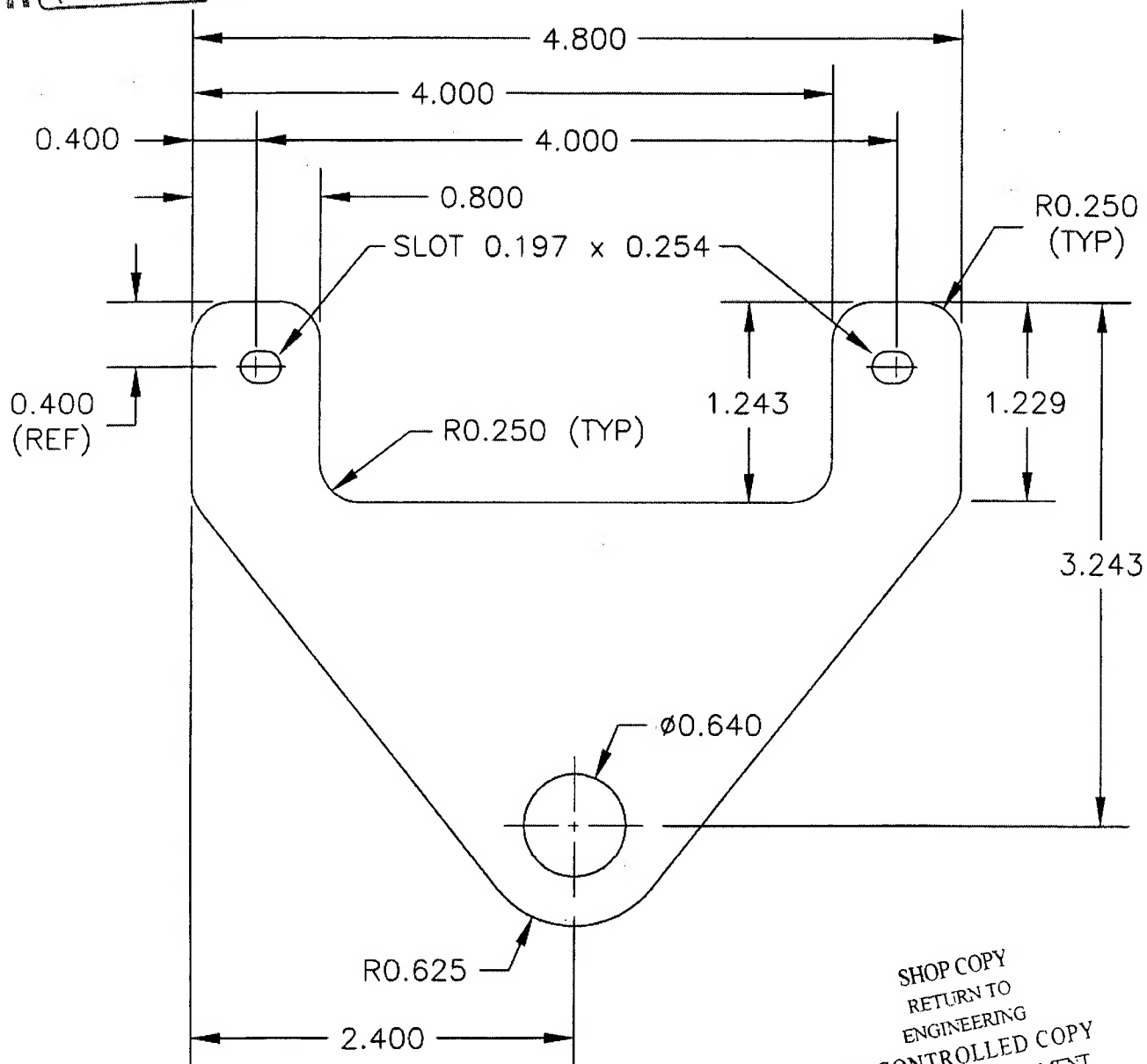


MATERIAL: 5052-H32 (QQ-A-250/8), 0.090 THICK
FINISH: POWDER COAT CRINKLE BLACK (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2052	REV. C SHEET 2 OF 2
DATE 99.04.30	TITLE BRACKET		SCALE 1:1

RELEASED
99.05.11 KE



D2052 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8), 0.090 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36617

